Date:

Tuesday, 22/04/2008 3:53:35 PM

Üser:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 38761

Estimate Number

: 12723

P.O. Number

This Issue Prsht Rev.

: 22/04/2008 : NC

First Issue **Previous Run** : //

: 38564

Type

S.O. No. :

: SMALL /MED FAB

Part Number Drawing Number : D353613 : D3536 REV A

: GASKET

Project Number

: N/A

Drawing Revision Material

Drawing Name

Due Date

: 02/05/2008

Qty:

20 Um:

Each

Written By

Checked & Approved By Comment

: 371) : Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 MNEO60S063

NEOPRENE SHEET 0.063



Comment: Qty.: 0.8682 sf(s)/Unit Total: 17.3649 sf(s)

NEOPRENE SHEET 0.063

Batch: 107655

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A Prog Rev: A 图 8-4-38



2-Deburr if necessary

3.0

QC2

188-4-D8

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_

Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE By Date			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-						

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC	on of NC Corrective Action Section B			Varification	Approval	Ammerial
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
				*			
ļ						-	
			·				
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Approval Chief Eng

NOTE: Date & initial all entries

Date:

Tuesday, 22/04/2008 3:53:35 PM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38761

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



FINAL INSPECTION/W/O RELEASE

08/04/30/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-29.

Dart Ae	rospace	e Ltd							
W/O:		,	WC	ORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						į			
								:	
Part No	:	PAR #:	Fault Cate	gory: N	CR: Yes	No DQA	\: <u> </u>	_ Date:	·
					QA: N	/C Closed	l:	_ Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMANC	E (NCR	4)			
		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio		Chief Eng	QC Inspector
								ļ	
							;		
							<u>.</u>		

NOTE: Date & initial all entries

z DOCUMENT ᄶ Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 유 COPIED

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

ENGINEERING

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) SEE PAGE 8 FOR DETAILS AND SECTION

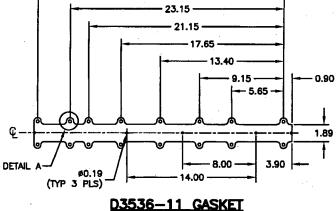
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

SHOP COPY RETURN TO

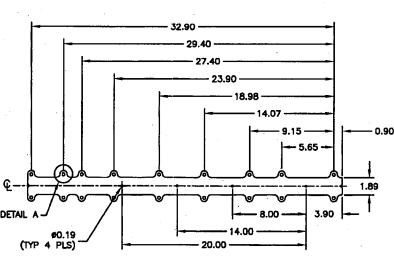
MOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60

DUROMETER (REF DART SPEC. M-NEO60-S.063)



26.65



	32.90
· -	29.40
	27.40
	23.90
Q DETAIL A SO 19	18.98 14.07 9.15 0.90 1.89 1.89
(TYP 4 PLS)	20.00 D3536-13 GASKET

	CB	CB	DART /	DART AEROSPACE USA, INC.
CHECKED	•	APPROVED /	DRAWING NO.	REV. A
	3	#	D3536	SHEET 1 OF 6
 DATE			37111	SCALE
06.10.25).25		GASKET	1:10
٨		06.10.25	anssi man	



20.02.12

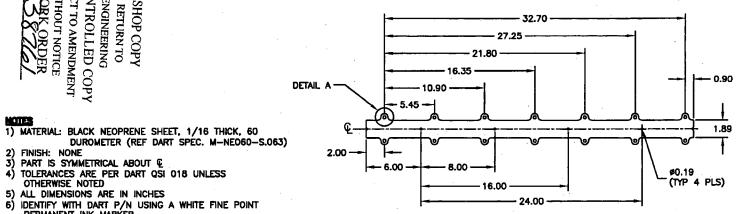
WITHOUT NOTICE

ENGINEERING

SHOP COPY RETURN TO

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT €
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

35.65 33.65 30.15 24.90 19.65 14.40 0.90 - 5.65 #0.19 (TYP 4 PLS) 8.00 3.90 24.00 D3536-15 GASKET UNCONTROLLED COPY SUBJECT TO AMENDMENT

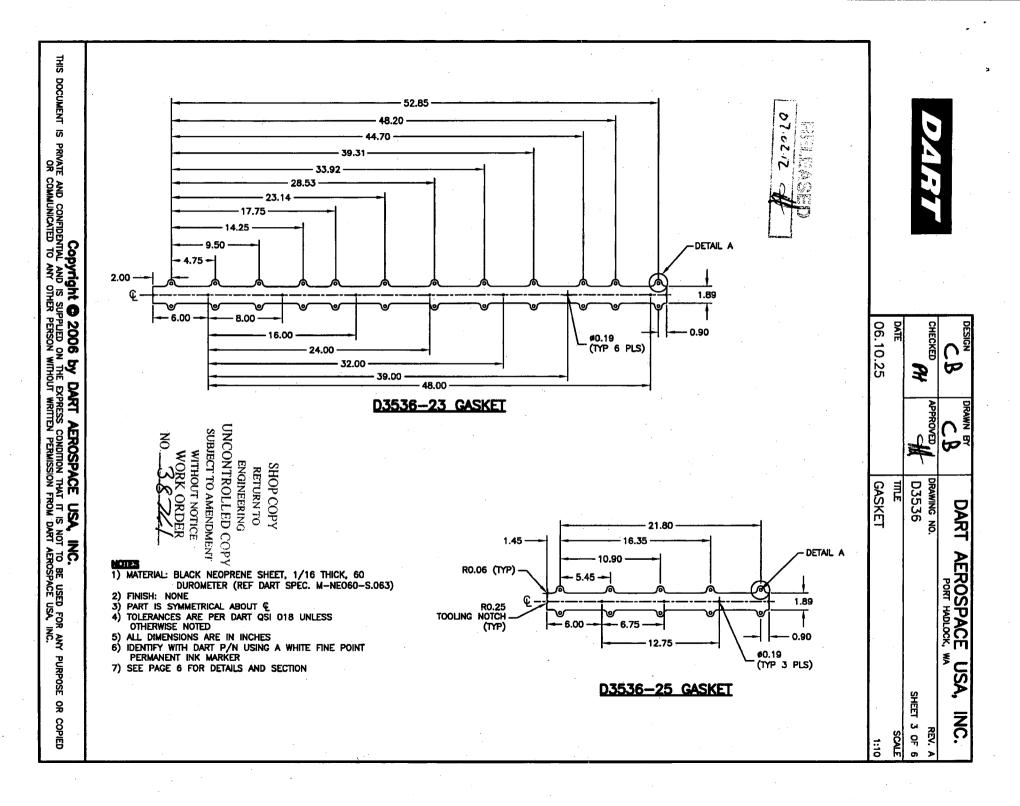


2.00 - 5.45	8.00	32.70 ————————————————————————————————————	 0.90 1.89 \$0.19 (TYP 4 PLS)

CB	CB	DAKI AEKOSTACE USA, INC.
CHECKED	APPROVED [DRAWING NO. REV. A
Z	Z	D3536 SHEET 2 OF 6
DATE		TITLE SCALE
06.10.25		GASKET 1:10



07.02.12



DETAIL A #0.19 (TYP 3 PLS)

D3536-31 GASKET

19.00

- 6.00 --

07.02.12 24/27 24/20 TE SO 21.00 2.00 -6.00 --1.89 6.00 DETAIL A **#0.19** (TYP 3 PLS)

D3536-33 GASKET

WORK ORDER WITHOUT NOTICE

2.00 -

Œ-

1.89

캪

DOCUMENT

ឆ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

윢 COPIED

ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY **RETURN TO**

6.00

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DART SPEC, M-NEOSO-S

 2) FINISH: NONE

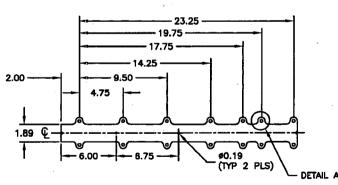
 3) PART IS SYMMETRICAL ABOUT €

 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED

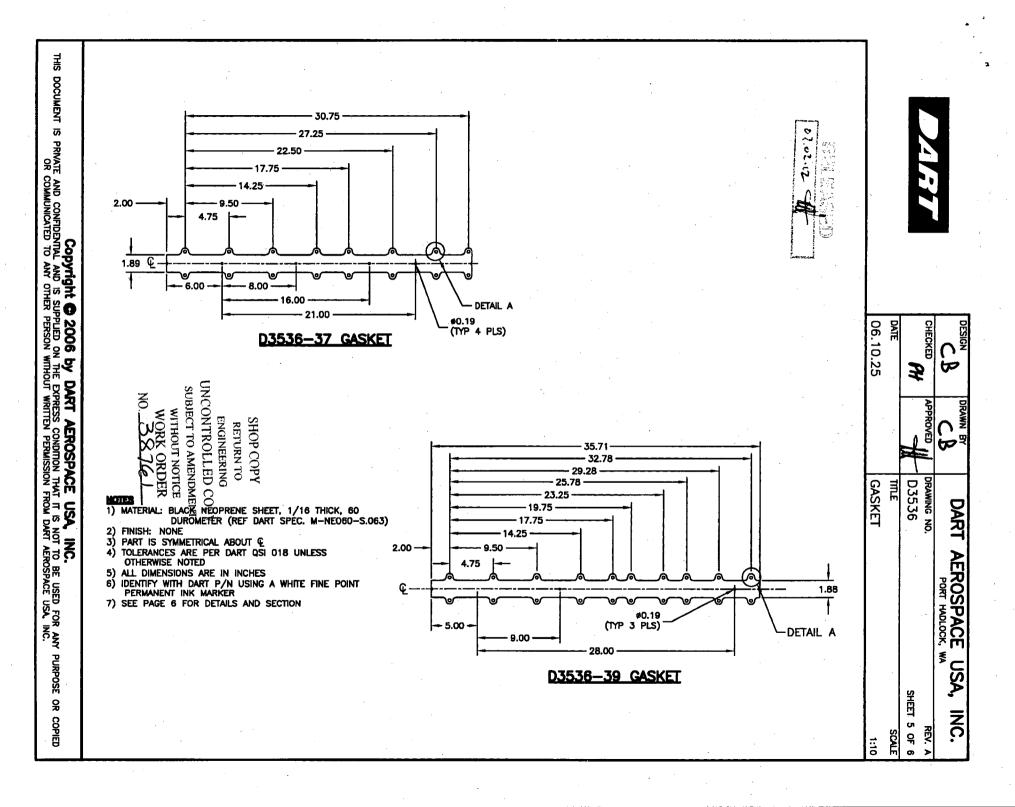
 5) ALL DIMENSIONS ARE IN INCHES

 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER

 2) SEE BACE 6. FOR DETAILS AND SECTION
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-33 GASKET	06.10.25	DATE	PH		CB CB
23.25			1	APPROVED /	DRAWN BY
19.75 ————————————————————————————————————	GASKET	TUIT	D3536	DRAWING NO.	DART
.00 - 6.75 - 60.19 (TYP 2 PLS) DETAIL A					DART AEROSPACE
<u>D3536-35 GASKET</u>	1:10	SCALE	SHEET 4 OF 6	REV. A	WA, INC.







D3536-41 GASKET

#0.19 (TYP 2 PLS)

1.88

3.90

SHOP COPY

RETURN TO

ENGINEERING

SUBJECT TO AMENDMENTO

WITHOUT NOTICE

WORK ORDERS

1) MATERIAS

1) MATERIAS

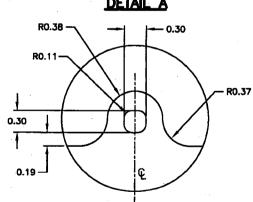
2) FINISH: NONE

3.43

DETAIL A

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



	06.10.25	DATE	PH	CHECKED	C B
DETAIL A RO.38 — — 0.30			#	APPROVED *//	DRAWN BY
R0.11 - R0.37	CASKET	TILL	D3536	DRAWING NO.	DART /
					DART AEROSPACE (
	1:10	SCALE	SHEET 6 OF 6	REV. A	USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹 COPIED

봀

DOCUMENT

ß

2.00 -

4.00

DART AEROSPACE LTD	Work Order: 3876
Description: GASKET	Part Number: D 3(36-13
Inspection Dwg:D376-13 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	t Ominacia
Ø ,19	1,005001	, 19	*			
.30 x 30	14- 220	30x.30	*			·
.90	1/030	.90	*			
1.89	11- 020	1.895	*			
3.90	1/030	3.905	X			
8.00	4- 030	8.00	×			
14.00	1/038	14.00	×			
30.00	1/- :038	00.06	*			
23.2	41- 020	5.65	*			
9.15	1- 030	_	*			
	+1_ 030		*			
18-98	1/- 630	18.98	*			
09.EC	1/030	23.90	*			
27.40	th .030	27.40	*	! 		
	4030		*			
39.90	7030	33.90	*			
						-
						•
		Î				
		j				

				•			I
Messured by: 🗷	Audited by:	5		Prototype /	Approvat:	M	
Date: 9-428	Date:	08	cu 28		Date:		7

D- 15			
Rev Date	Change	Revised by	Approved
Δ	Now Inches		1.77.
	New Issue	KJ/JLM	1
		7 (0) 0 12//-	

